

Date: Thursday, 20/11/2008 3:36:49 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 43641	
Estimate Number : 12949	
P.O. Number :	Part Number : D3259042
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3249 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 34674	Material :
Written By :	Due Date : 21/12/2008 Qty: Um: Each
Checked & Approved By : <u>JA 08.11.21</u>	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Assembly Kit

2.0	D32591	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 panel  
 Batch: B44301

FF 09-03-17

⑥

3.0	D32594	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Doubler  
 Batch: B44303x3 / 43773x3

FF 09-03-17

⑥

4.0	D32595	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Spacer  
 Batch: B43724

FF 09-03-17

⑥

5.0	D32597	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Door  
 Batch: B44304

FF 09-03-17

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:36:49 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 43641

Part Number: D3259042

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D31615	Hinge 9.9"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Hinge 9.9"  
Batch: 46473

FF 09-03-17

(6)

7.0	D32601	Spring
-----	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Spring  
Batch: 44305 x 6 / B43775 x 6

FF 09-03-17

(6)

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
HALF GROMMET  
Batch: M110118

FF 09-03-17

(6)

9.0	250018C3Y	RIGHT RECEPTACLE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
RIGHT RECEPTACLE  
Batch: M105932

FF 09-03-17

(6)

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
STUD  
Batch: M100398

FF 09-03-17

(6)

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Rivet  
Batch: M15541

FF 09-03-17

(6)

12.0	MS20470AD34	Rivet, Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)  
Rivet, Universal Head  
Batch: M15541

FF 09-03-17

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 20/11/2008 3:36:49 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 43641

Part Number: D3259042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS20470AD35	Rivet
------	-------------	-------



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Rivet  
Batch: M9682

FF 09-03-17

6

14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3259-041 as per Dwg D3259.  
Note: Keep .040" Gap all around door.

FF 09-03-17

6

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/03/17 (x6)

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

9/3/17

6

SP

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

Job Completion



ME 09-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

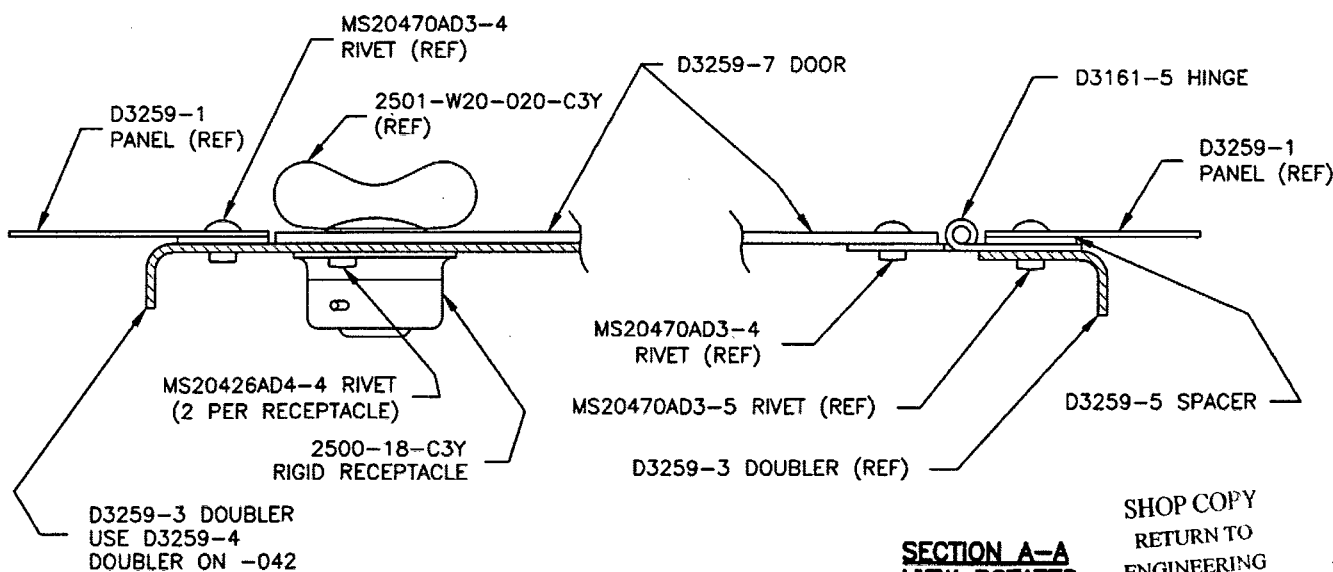
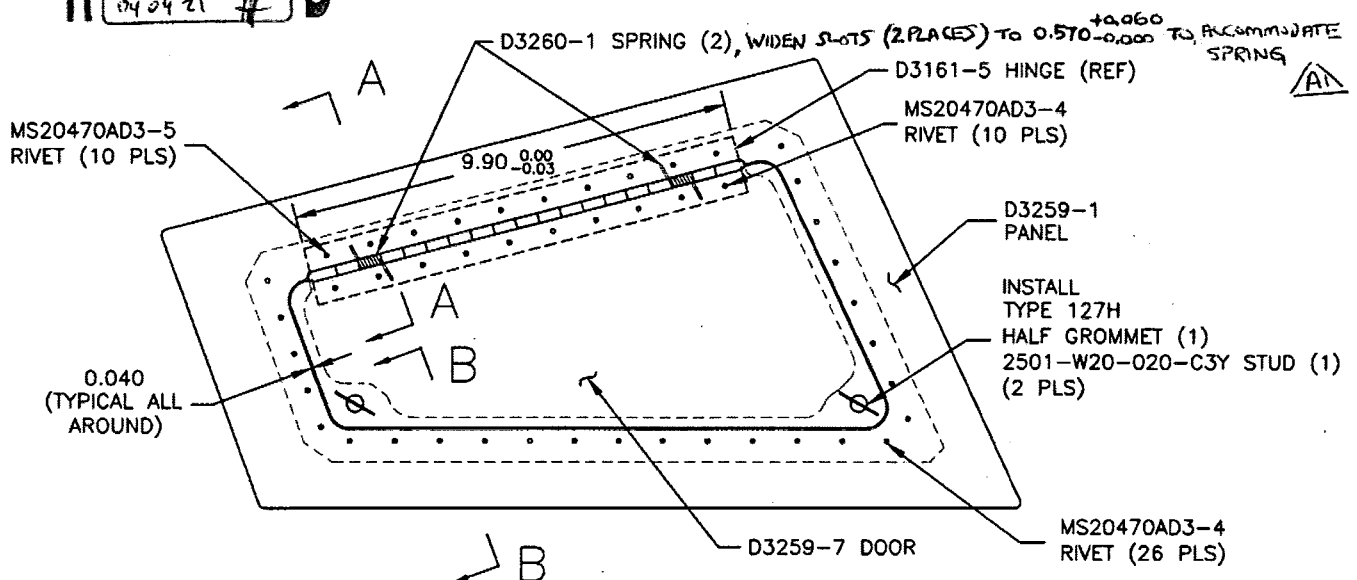
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	RF	DRAWN BY	UP	DART AEROSPACE LTD	
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					SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:4
A	04.02.25	NEW ISSUE			
AI	UP # 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING			

RELEASED  
040421 #



SECTION B-B  
VIEW ROTATED

SECTION A-A  
VIEW ROTATED

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NO. 43641

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)

D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

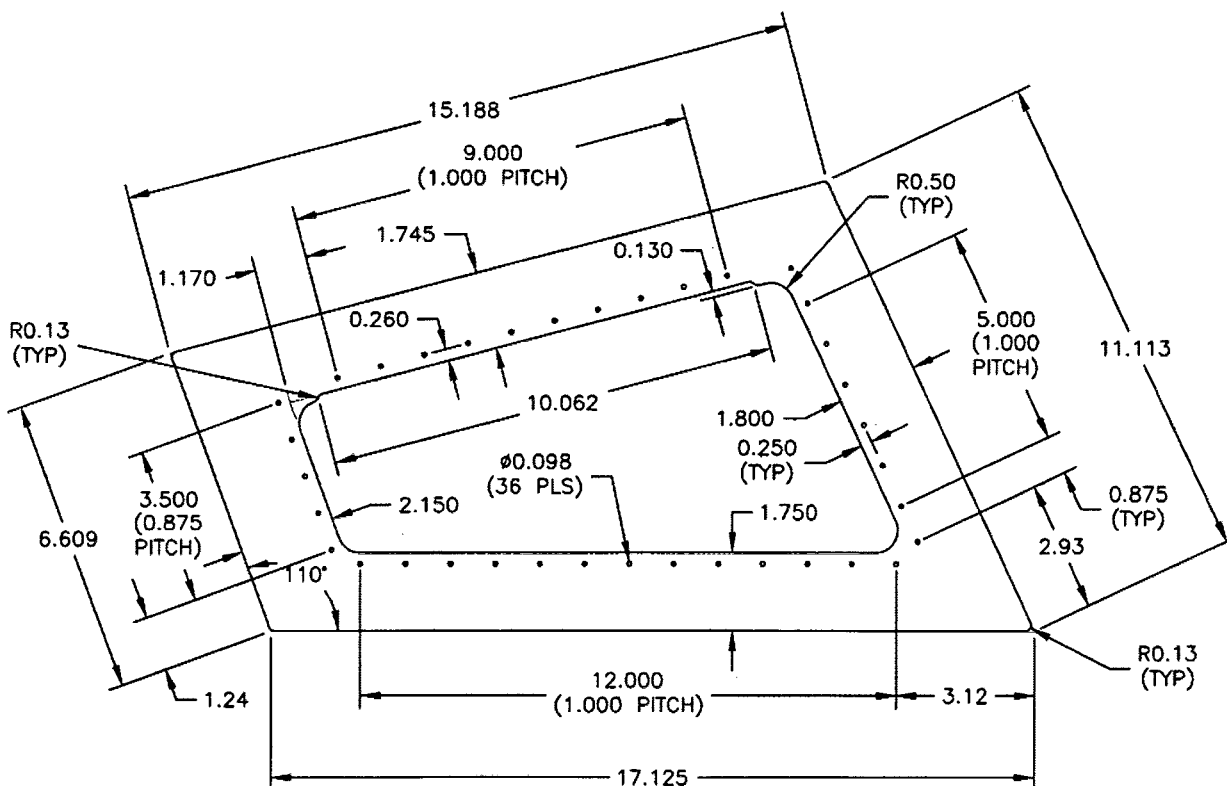
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



**D3259-1 PANEL**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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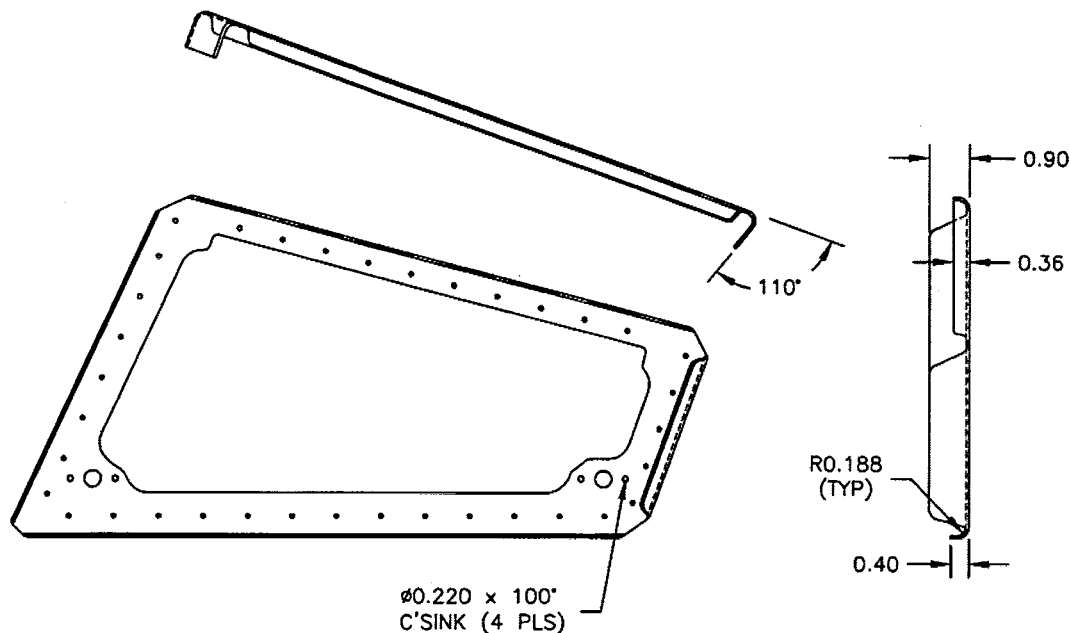
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**  
BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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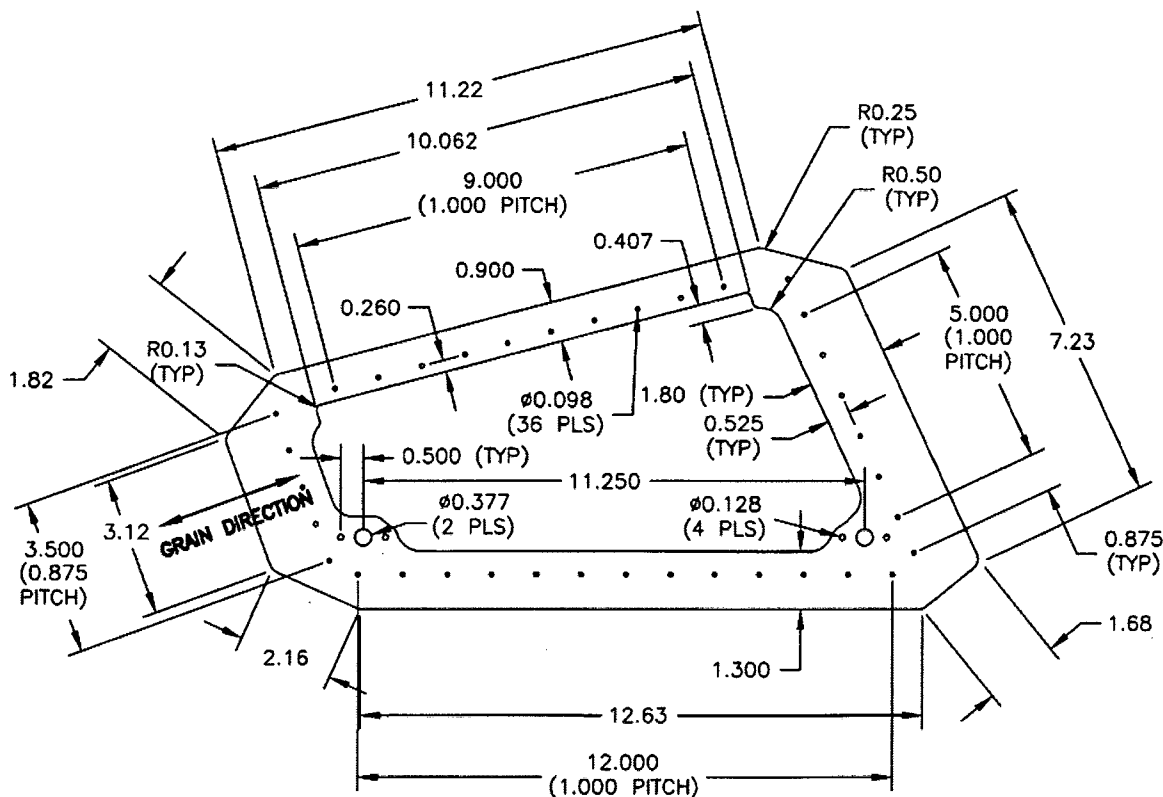
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14 [Signature]







**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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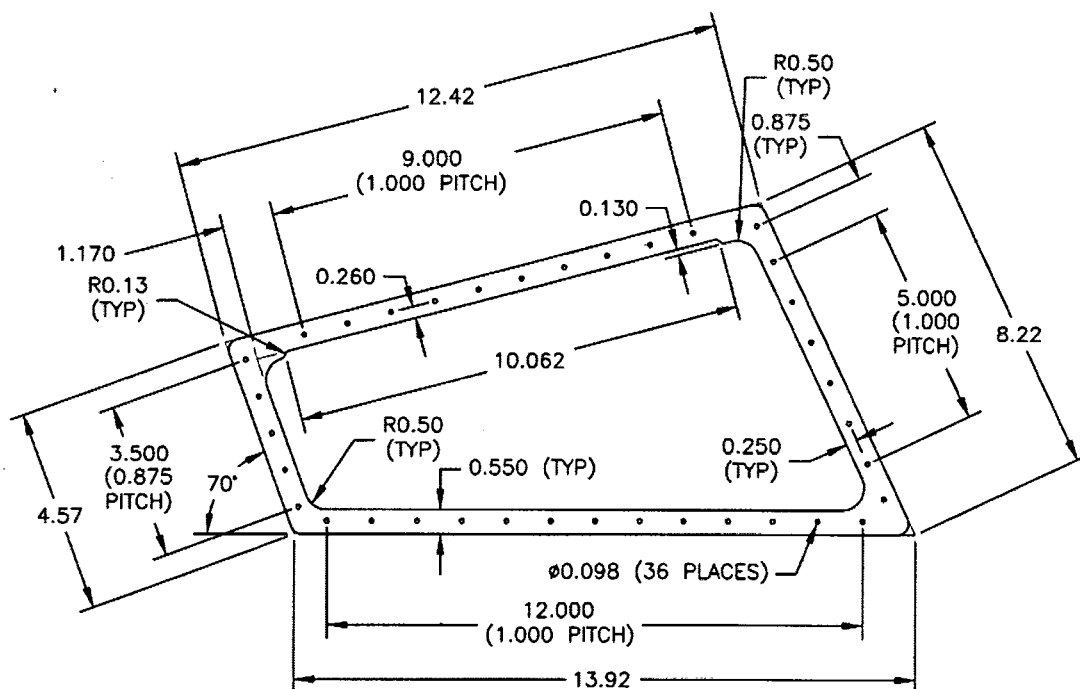
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RELEASED  
04-04-05



**D3259-5 SPACER**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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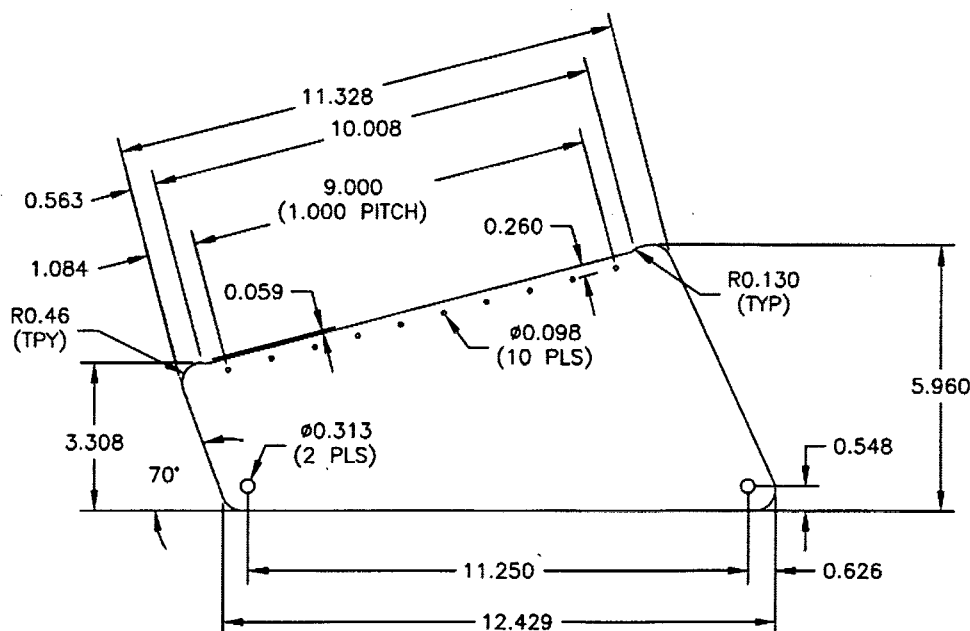
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
07-24-14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"  
 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)  
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 UNCONTROLLED COPY  
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT  
 5) ALL DIMENSIONS ARE INCHES WITHOUT NOTICE  
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER

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